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D4355-1
Job Sheet 187632



Part No: D4355-1

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	4 pcs		12/21/18	0.00	1.91	Waterjet - Flow		SC 19/02/19
130	CNC Vertical Machining	4 pcs		12/21/18	0.95	13.33	HAAS1-4		KT 19-02-09
140	QC	4 pcs		12/21/18	0.00	0.00	QC2 Machining-2		KT 19-02-09
150	QC	4 pcs		12/21/18	0.00	0.00	QC8 Machining-2		SK 19/02/12
151	Packaging	4 pcs		12/21/18	0.00	0.00	Packaging3	5/438A	6
190	QC21-SA	4 Ea		12/21/18	0.00	0.00	QC21		FEB 13 2019

Part Op 120 - Cut Blank as per D4355-1 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining. 3-Machine as per Folio FB049 and Dwg. 4-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	21.2000 sf (5.3 ea)	120-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	21	245	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw (206L/407)	6.625Inches ± 0.010	6.635 6.615		
2	Bearpaw (206L/407)	4.000Inches ± 0.010	4.010 3.990		
3	Bearpaw (206L/407)	2.313Inches ± 0.010	2.323 2.303		
4	Bearpaw (206L/407)	9.125Inches ± 0.010	9.135 9.115		
5	Bearpaw (206L/407)	2.312Inches ± 0.010	2.322 2.302		
6	Bearpaw (206L/407)	27.000Inches ± 0.030	27.030 26.970		
7	Bearpaw (206L/407)	0.250Inches ± 0.030	0.280		

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DART
AEROSPACE

Route update only

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J

			0.220
8	Bearpaw (206L/407)	0.070Inches $\pm$ 0.030	0.100 0.040
9	Bearpaw (206L/407)	45.0Degrees $\pm$ 5.0	50.0 40.0
10	Bearpaw (206L/407)	0.300Inches $\pm$ 0.030	0.330 0.270
11	Bearpaw (206L/407)	45.0Degrees $\pm$ 5.0	50.0 40.0
12	Bearpaw (206L/407)	5.500Inches $\pm$ 0.030	5.530 5.470
13	Bearpaw (206L/407)	0.261Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.267 0.260
14	Bearpaw (206L/407)	0.650Inches $\pm$ 0.010	0.660 0.640
15	Bearpaw (206L/407)	0.500Inches $\pm$ 0.030	0.530 0.470
16	Bearpaw (206L/407)	1.0Inches $\pm$ 0.0	1.0 0.9
17	Bearpaw (206L/407)	0.630Inches $\pm$ 0.030	0.660 0.600
18	Bearpaw (206L/407)	0.380Inches $\pm$ 0.030	0.410 0.350
19	Bearpaw (206L/407)	0.060Inches $\pm$ 0.030	0.090 0.030
20	Bearpaw (206L/407)	45.0Degrees $\pm$ 5.0	50.0 40.0

Plex 12/10/18 2:29 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

DISPOSITION

Rework ☐
Scrap ☐

Skid-tube
Machining ☐

Cross tube
Small Fab ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec./Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Job: _____

Part No. _____

Date: _____

Descriptive

Part: D4355 - 1
Job No: 187632
Serial No/Batch: S147794
Inspector:
Exp Date:
Instructions: Various STC's

Date: 01/24/19



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MRB (QSI042)

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

Bending ☐

Crushing ☐

Cracks ☐

Crimp/Kink/Ripple/Wave/Twist ☐

Marks/Chatter ☐

Mislabeled ☐

BOM/Route ☐

Broken/Damage/Defect ☐

Incomplete/Unclear Instructions ☐

Drill Holes ☐

Fit/Function ☐

Stress/Surge ☐

Program ☐

Grinding Direction ☐

Weld ☐

Wrong Stock Pulled ☐

Out of Sequence ☐

Off-set/Set-up ☐

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details: